

Work Order ID 91386-1-4

91386

Page 1

October-05-12 11:36:46 AM

Item ID: D4410-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Conduit

Stop *NS2*

Start Date: 10/05/12

Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/12/12

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

ML5

Date: 12-10-05 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4410

REV B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

BEND AS PER DWG

DEBURR

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: v/p

0.00

120

Packaging

Memo

0.00

Packaging

FF
12-11-08

DAS
15
08

1271-08

EL 12-11-8

Work Order ID 91386

October-05-12 11:36:46 AM

91386

Page 2

Item ID: D4410-7

Revision ID:

Item Name: Conduit

Start Date: 10/05/12 Start Qty: 12.00

Required Date: 10/12/12 Req'd Qty: 12.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/11/12

12-11-08

Picklist Print

October-05-12 11:36:46 AM

Page 1

Work Order ID: 91386
 Parent Item: D4410-7
 Parent Item Name: Conduit

Start Date: 10/05/12

Required Date: 10/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD
 13 JFS VERIFIED BY:JLM

IPP REV:B AS PER PB6 12-08-

Component Item ID/
 Item Name

Replacement
 Item ID

Mfg/
 Purch

Bin
 Item

Primary
 Location

Last
 Location

Route
 Seq ID

Unit of
 Measure

Qty on
 Hand

Qty per Kit

Total
 Qty

Qty
 Issued

Date
 Issued

Status

M6061T6T0.625W.049

6061-T6 RD Tube .625 x .049W

Purchased

No

f

63.6252

21.473684

FF. 12-11-08

Location

Loc Qty

Loc Code

MAT014

20.244

107967

5.16

118390

15.084

WA035

43.3812

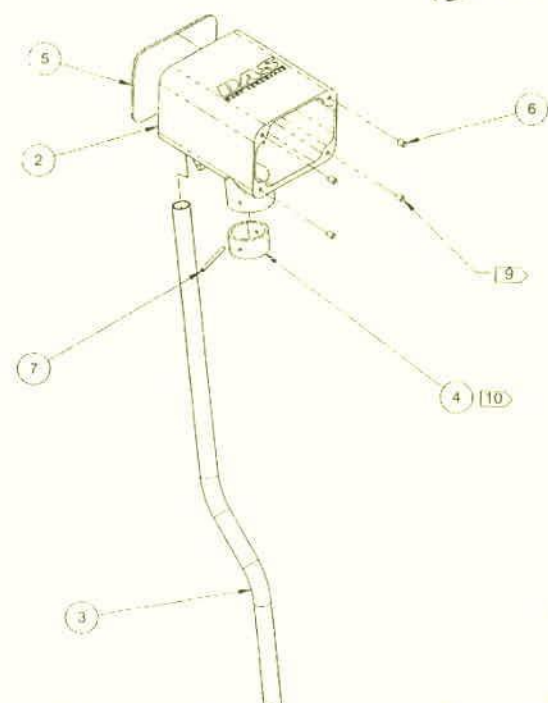
121170

43.3812

25.0516

ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171539	PIN

91386 MLJ
12-10-05



D4410-041 WELDING DETAIL
(-041 SHOWN, -043/-045 SIMILAR)

- NOTES
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.55 lbs
 - 8) WELD PER DART QSI 004
 - 9) INSTALL AFTER ANODIZING
 - 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

B	ADD CBORE, ZN A4-2 ENLARGE HOLES, ZN C5-3 & B8-3, UPDATE LOGO, ADD -045/-11/-13/-15, ROTATE HOLE, ZN C3-2, INCREASE -7 DIAMETER, ZN C1-6 REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1	DC	12.07.30
A	NEW ISSUE	DC	11.06.06
REV	DESCRIPTION	BY	DATE
DESIGN	BC		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.07.30		

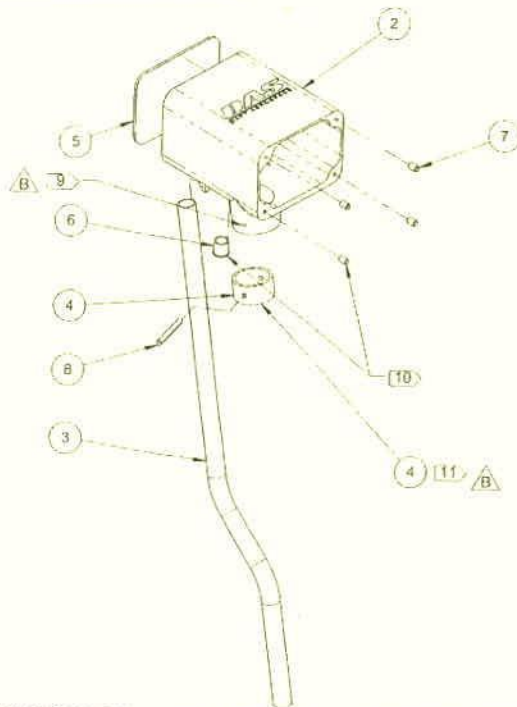
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4410** REV. B
SHEET 1 OF 12

TITLE **CO-PILOT COLLECTIVE HEAD** SCALE NTS

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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1	MS171599	PIN



91300

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR II OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

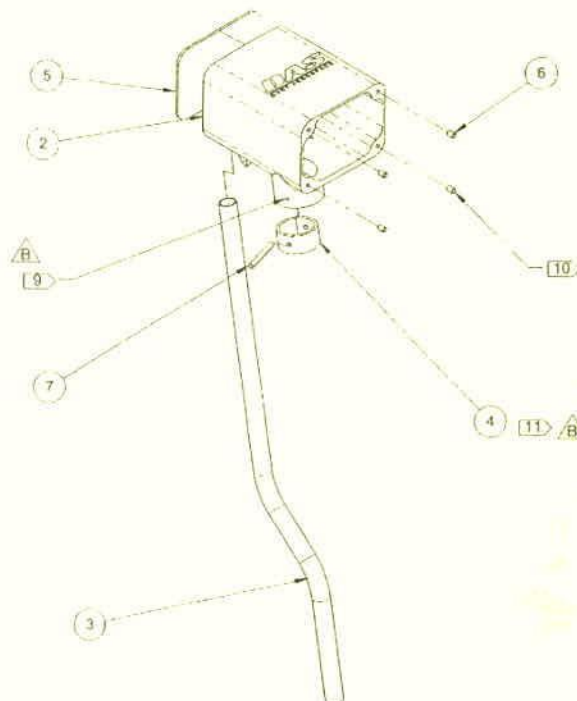
D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

RELEASE

2012-09-28

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 2 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90206A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171599	PIN

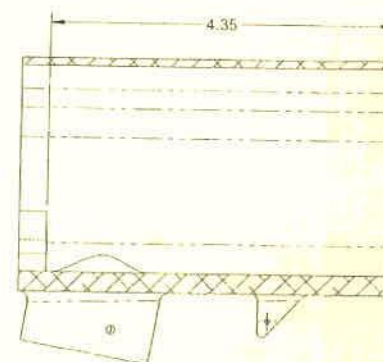
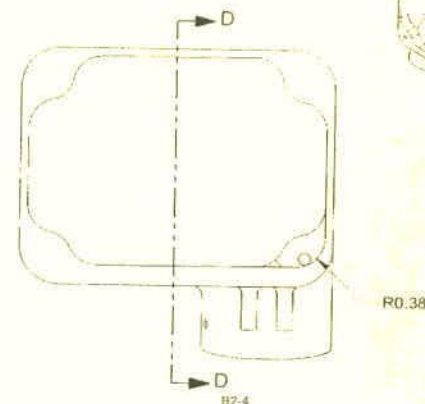
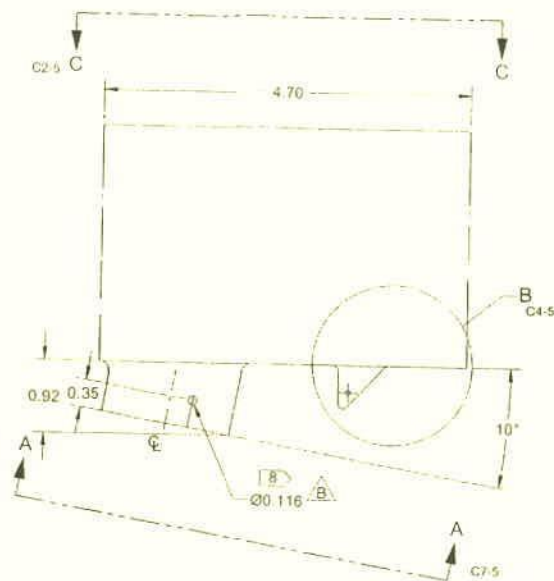


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 893 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

**D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY
(EAGLE SINGLE)**

DESIGN	DC	DART AEROSPACE USA, INC.	
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CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	BT	D4410	SHEET 3 OF 12
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	CO-PILOT COLLECTIVE HEAD	NTS
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RELEASE
2012-09-26 L
WDP

Technical drawing of a mechanical part, likely a valve or actuator assembly, showing a side view with dimensions and features.

Dimensions and Features:

- Overall width: 2.00
- Distance from left edge to center of first hole: 1.782
- Height of main body: 1.50
- Top hole diameter: $\phi 0.115$
- Top hole specification: CSK $\phi 0.188 \times 100^\circ$ 2 PL
- Right hole diameter: $\phi 0.500$
- Distance from right edge to center of right hole: 0.254 $\begin{matrix} +0.005 \\ -0.000 \end{matrix}$ (Feature B)
- Distance from right edge to center of top hole: 0.20 TYP
- Left hole diameter: $\phi 0.160$
- Distance from left edge to center of left hole: 0.83
- Distance from left edge to center of middle hole: 0.38
- Distance from center of middle hole to center of right hole: 2.16
- Bottom hole diameter: $\phi 0.750 \times 0.150$ DP (Feature B)
- Bottom hole depth: 0.50

Additional notes:

- 8/4115/4116)
- D

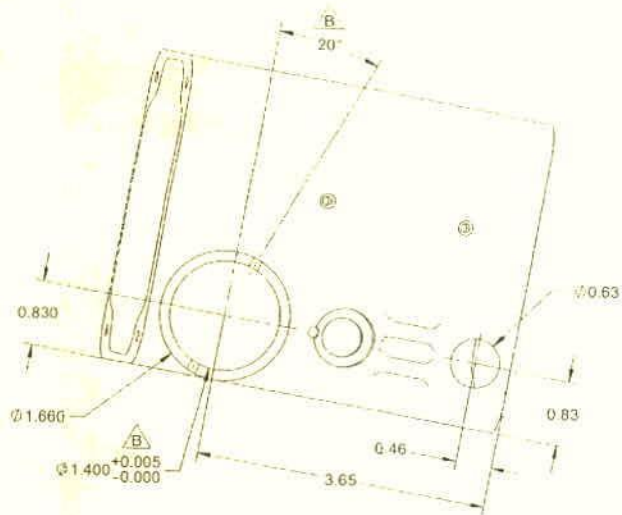
DE
DF
CH
MF

DESIGN	DC
DRAWN	DC
CHECKED	AS
MFG. APPR.	SA
APPROVED	NO
DE APPR.	HA
DATE	12.07.30

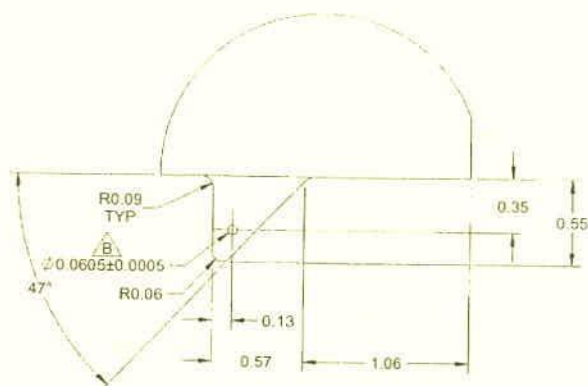
DRAWING NO.	REV. B
D4410	SHEET 4 OF 12
TITLE	SCALE
CO-PILOT COLLECTIVE HEAD	NTS

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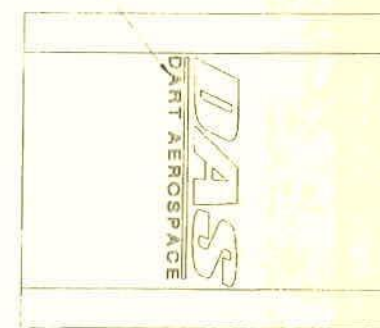
91386



VIEW A-A
C5-4



DETAIL B
C4-4



VIEW C-C
D4-4

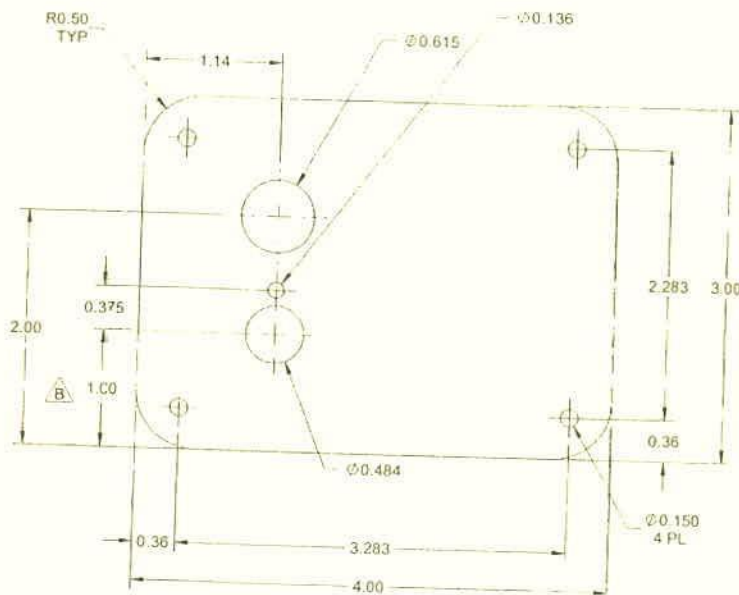
**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

RELEASED
2012-09-28

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

DESIGN	DC	DART AEROSPACE USA, INC.	
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CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	GI	D4410	SHEET 5 OF 12
APPROVED	NO	TITLE	SCALE
DE APPR.	TH	CO-PILOT COLLECTIVE HEAD	NTS
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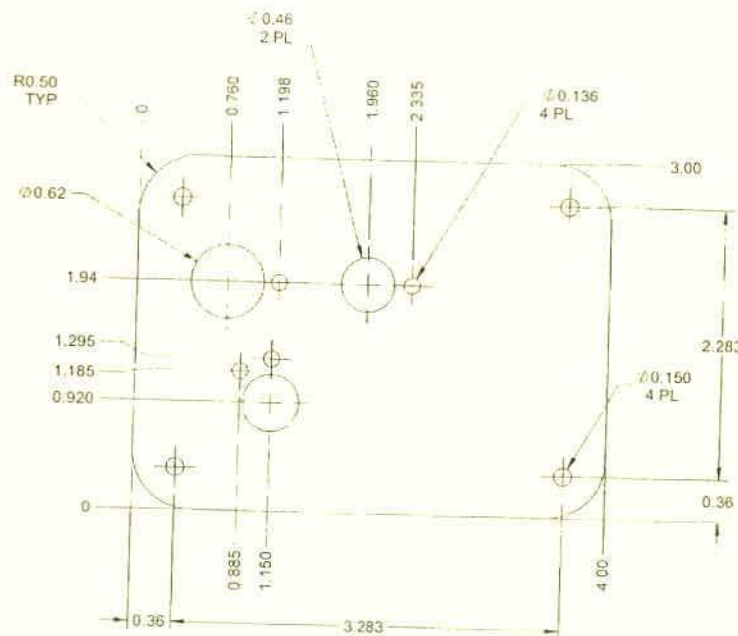
D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M8061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT 0.04 lbs

2012-08-28

DESIGN	BC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 6 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



D4410-5 FACE PLATE

NOTES:

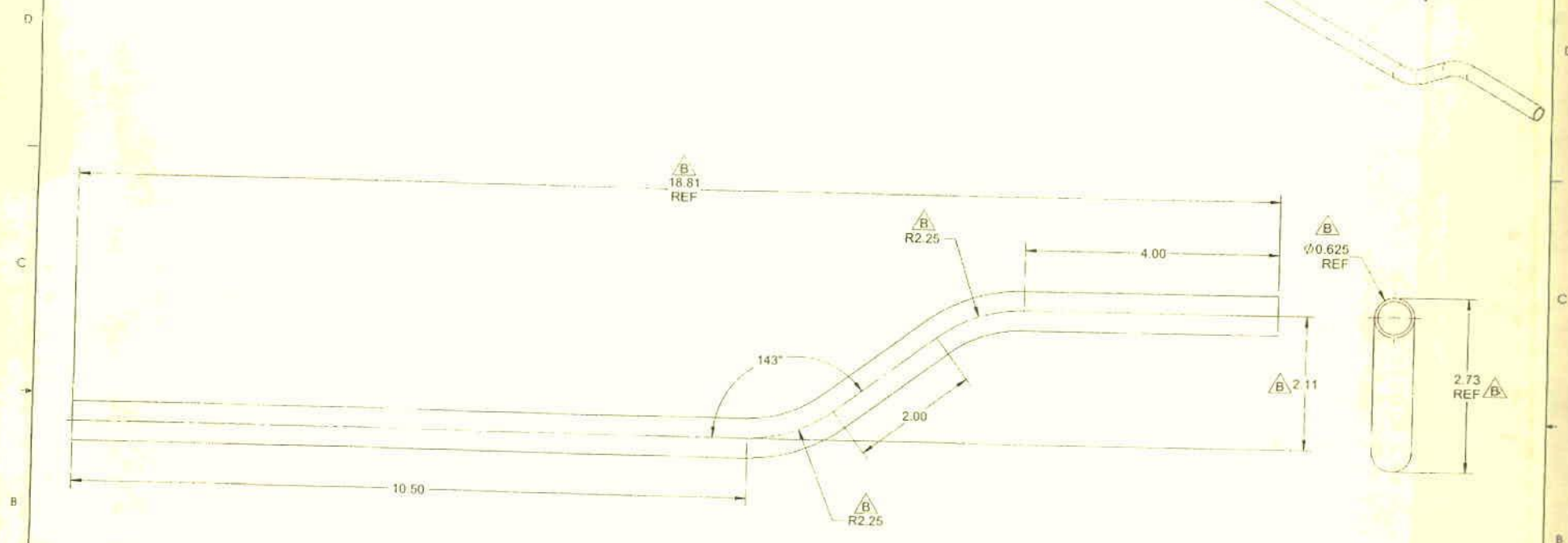
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2012-09-28

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO	REV. B
MFG. APPR.	BC	D4410	SHEET 7 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
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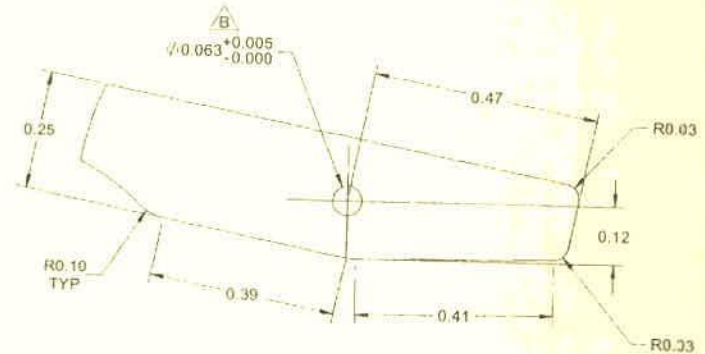
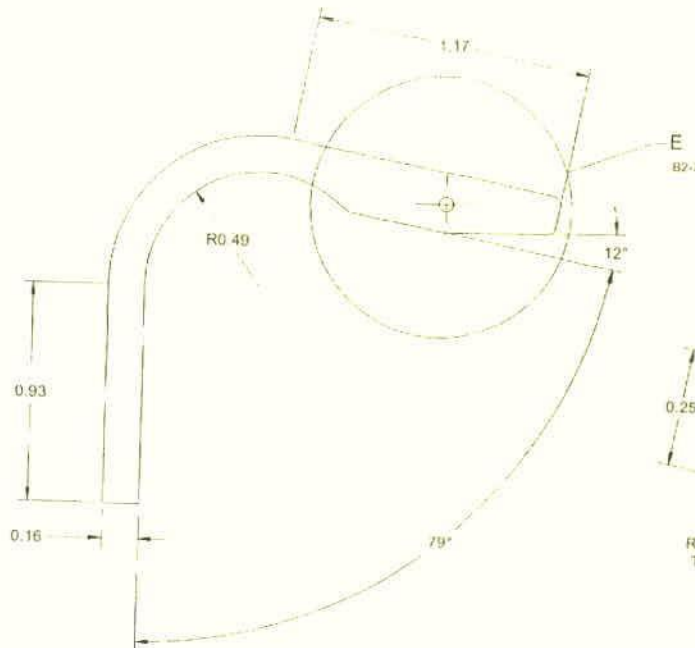
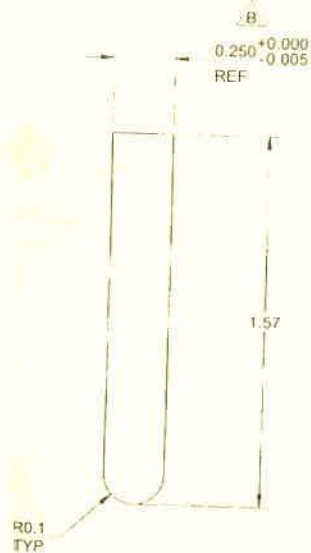
D4410-7 CONDUIT

NOTES:

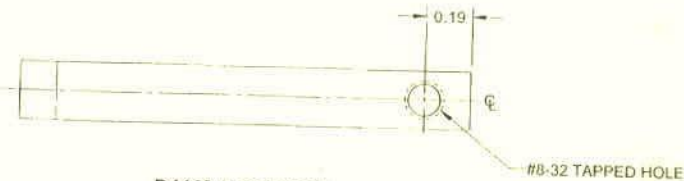
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC. M6061T60.625W.050
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

RELEASE
2012-09-28
JNP

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 8 OF 12
A*PROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



DETAIL E
D4-7



D4410-9 TRIGGER

NOTES

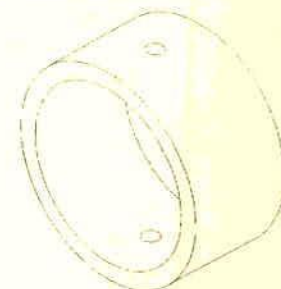
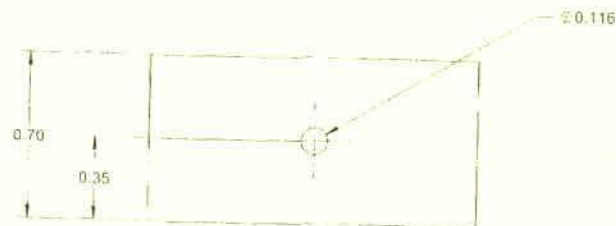
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	DC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG APPR.	DC	D4410	SHEET 9 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	

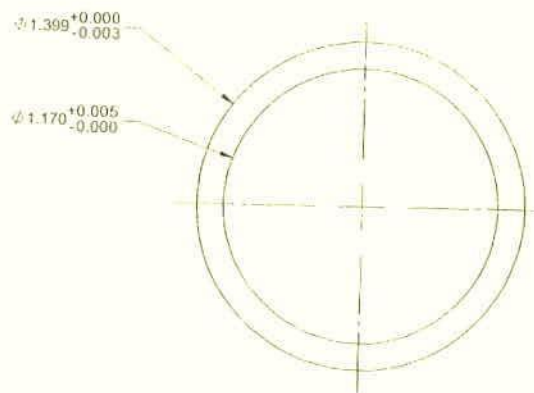
RELEASED
2012-09-23
ANN

91386





91386



D4410-11 205 SHIM

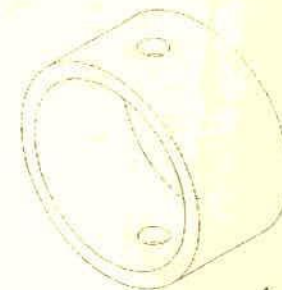
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2012-09-23
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NOTES

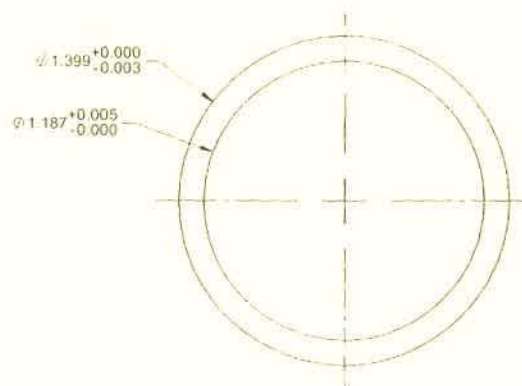
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M8061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 10 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR	BC	CO-PILOT COLLECTIVE HEAD	NTS
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91386



D4410-13 212 SHIM

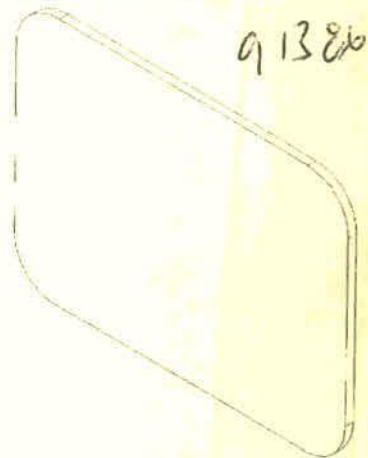
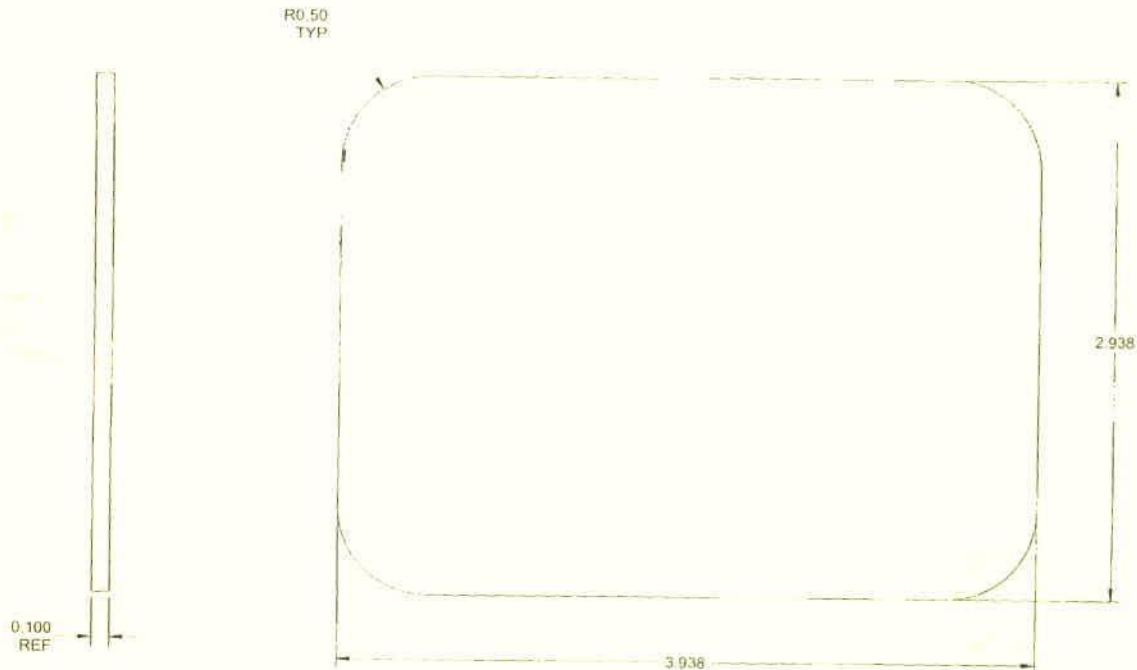
RELEASED
2012-09-28
WHD

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO. D4410	REV. B
MFG. APPR.	DC	SHEET 11 OF 12	
APPROVED	DC	SCALE	
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD NTS	
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D4410-15 REAR COVER

2012-03-28

NOTES

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S.100.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO. D4410	REV. B
MFG. APPR	BC	SHEET 12 OF 12	
APPROVED	BC	TITLE	SCALE
DE APPR	BC	CO-PILOT COLLECTIVE HEAD	
DATE	12.07.30	NTS	

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